

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017910**Date Inspected:** 02-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS OBG**Summary of Items Observed:**

The Quality Assurance (QA) Inspector, Rick Bettencourt was on site at the job site between the times noted above.

The QA Inspector was on site to randomly observe the in process welding and inspection of the weld joints identified as hole restoration 3E-pp17-E4-3, 2E-pp15-E3-4 and the following observations were made:

3E-pp17-E4-3

The QA Inspector randomly observed the ABF welder identified as Eric Sharp performing grinding tasks on the above identified back gouged weld joint. The QA Inspector randomly observed the Smith Emery (SE) Quality Control (QC) Inspector John Pagliero perform magnetic particle testing several times in an attempt to clear or accept the back gouged weld joint. The QA Inspector randomly observed the back gouged weld joint and noted several MT indications were present and additional grinding would be required. After the grinding was completed, and the weld was re-tested the QA Inspector noted the MT indications had been removed and the back gouged weld joint appeared to be acceptable. The QA Inspector randomly observed the ABF welder begin performing the SMAW back weld for the above identified weld joint. The QA Inspector noted the base metal and the weld joint were preheated to approximately 100°F and back welding was commenced. The QA Inspector randomly observed the ABF welder to be utilizing 1/8" E7018 low hydrogen electrodes with 132 Amps. The QA Inspector noted the SMAW back weld was continued from the previous day shift completed on the QA Inspectors shift on this date. The QA Inspector randomly observed the ABF welder begin performing grinding tasks in an attempt to remove and grind the weld reinforcement flush with the base material.

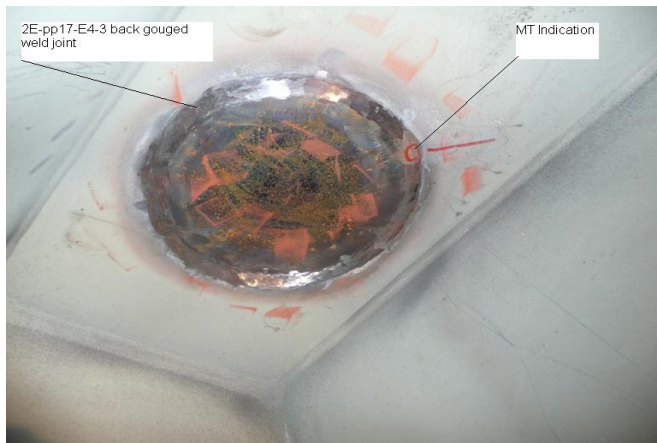
2E-pp15-E3-4

The QA Inspector randomly observed the ABF welder identified as Darcel Jackson performing grinding tasks on

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

the above identified back gouged weld joint. The QA Inspector randomly observed the Smith Emery (SE) Quality Control (QC) Inspector John Pagliero perform magnetic particle testing in an attempt to clear or accept the back gouged weld joint. The QA Inspector randomly observed the back gouged weld joint and noted no MT indications appeared too had been located at the time of the testing. The QA Inspector randomly observed the ABF welder begin performing the SMAW back weld for the above identified weld joint. The QA Inspector noted the base metal and the weld joint were preheated to approximately 100°F and back welding was commenced. The QA Inspector randomly observed the ABF welder to be utilizing 1/8" E7018 low hydrogen electrodes with 128 Amps. The QA Inspector noted the SMAW back weld was continued from the previous day shift completed on the QA Inspectors shift on this date. The QA Inspector randomly observed the ABF welder begin performing grinding tasks in an attempt to remove and grind the weld reinforcement flush with the base material.



Summary of Conversations:

No pertinent conversation noted.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mohammad Fatemi (916)-813-3677, who represents the Office of Structural Materials for your project.

Inspected By:	Bettencourt,Rick	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
